



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4165-3
Job Sheet 169999



①

Part No: D4165-3

Job Qty: 2 ea

Part Name: Inner Door Panel



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/5/18

Job Tracking No:

Due Date: 1/26/18

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV B SHEET 2 IPP Rev:A 11.03.09 new issue DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		1/25/18	0.00	0.00	Start Up Waterjet		SC 18/01/08
100	Waterjet	2 pcs		1/25/18	0.00	0.19	Waterjet1		SC 18/01/08
120	QC	2 pcs		1/25/18	0.00	0.00	QC8		38
130	HandFinish	2 pcs		1/26/18	0.00	0.20	HandFinish1		2018/01/19 JSL
135	QC	2 pcs		1/26/18	0.00	0.00	QC7-3		38
140	Packaging	2 pcs		1/26/18	0.00	0.00	Packaging3		3-88
150	QC21-SA	2 Ea		1/26/18	0.00	0.00	QC21		21

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Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M2024T3S.040	7	81	0	0

M138389

7.54

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Inner Door Panel	0.640Inches ± 0.030	0.670 0.610	0.453	
2	Inner Door Panel	4.700Inches ± 0.030	4.730 4.670	4.70	
3	Inner Door Panel	6.030Inches ± 0.030	6.060 6.000	6.032	
4	Inner Door Panel	7.630Inches ± 0.030	7.660 7.600	7.639	
5	Inner Door Panel	8.600Inches ± 0.030	8.630 8.570	8.601	
6	Inner Door Panel	15.250Inches ± 0.030	15.280 15.220	15.25	
7	Inner Door Panel	2.550Inches ± 0.030	2.580 2.520	2.552	
8	Inner Door Panel	0.760Inches ± 0.030	0.790 0.730	0.763	
9	Inner Door Panel	33.790Inches ± 0.030	33.820 33.760	33.80	
10	Inner Door Panel	19.750Inches ± 0.030	19.780 19.720	19.75	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS							
		Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐					
		Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐					
		Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐					
Suspected Unapproved ☐		Large Fab ☐	Composite ☐	Supplier ☐							
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval				
Description Work Order Deviation				Disposition							
Job No: 169999 Mfg Date: 01/08/18 Start up Operation D4165-3 Revision: Operation: Change No: PART NO: D4165-3				Completed By							
				Lead hand / Supervisor Approval Verification							
				QC / QA Coordinator Approval							
Root Cause		Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com S030182 DART AEROSPACE Inner Door Panel		Positioned Wrong							
Environment ☐				No Re-verification ☐		Outside Dimensions					
Design ☐				Operator ☐		Over/Under tolerance					
Doc/Data ☐				Offset/Setup ☐		Part Incorrect					
Equip/Tooling ☐				Supplier ☐		Part Lost/Missing					
Handling/Pre ☐				Training ☐		Part Moved					
Material ☐				Use for Testing ☐		Drawing					
Internal Transport ☐				Poor Information ☐		Finish					
Tribal Knowledge ☐				Rushing ☐		Misread					
LOA ☐				Product Improvement ☐		Turning Sequence					
Substation ☐		Process Improvement ☐		OTHER : _____							
Past Expiry Date ☐		Manufacturing Process ☐									
Misidentified ☐		Past Due ☐									

11	Inner Door Panel	6.900Inches ± 0.030	6.930 6.870	6,901
12	Inner Door Panel	15.250Inches ± 0.030	15.280 15.220	15,25
13	Inner Door Panel	0.040Inches ± 0.010	0.050 0.030	0,040

Plex 1/5/18 1:01 PM dart.poulin.mario

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																													
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